



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3403-5

Job Sheet 178422



Part No: D3403-5

Job Qty: 20 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3403 REV F IPP REV:A NEW ISSUE 10-04-23 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Machining-2		52 18/07/04
100	Hardinge	20 pcs	6/8/18	6/8/18	0.08	3.01	Hardinge		9-89 18/07/04
120	QC	20 pcs	6/8/18	6/8/18	0.00	0.00	QC8		9-89 18/07/04
130	Packaging	20 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-1		9-89 18/07/04
140	QC21-SA	20 Ea	6/8/18	6/8/18	0.00	0.00	QC21		9-89 18/07/04

Part Op Descriptions: 100 - 1- Turn as per Folio FA925 & Dwg D3403 Folio Rev: _____ Dwg Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	4.2600 ft (.213 ea)	90-Start up Operation	5082805 5089087

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R0.750	4	71	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.750inches $\pm$ 0.010	0.760 0.740	.746	
2	Bushing	0.257inches $\pm$ 0.010 - 0.000	0.267 0.257	.261	
3	Bushing	0.060inches $\pm$ 0.005	0.065 0.055	.060	
4	Bushing	2.420inches $\pm$ 0.010 - 0.000	2.430 2.420	2.427	
5	Bushing	0.313inches $\pm$ 0.010	0.323 0.303	.313	
6	Bushing	60Degrees $\pm$ 0	60 60	60°	
7	Bushing	0.425inches $\pm$ 0.000 - 0.002	0.425 0.423	0.424	
8	Bushing	0.030inches $\pm$ 0.010	0.040	.03	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

			0.020	
9	Bushing	20Degrees $\pm$ 0	20	20
			20	
10	Bushing	0.010inches $\pm$ 0.010	0.020	01
			0.000	

Plex 5/31/18 12:45 PM Dart.lajeunesse.marie



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Container No: S089098



Part: D3403-5

Job No: 178422

Serial No/Batch: S089098

Revision: F

Inspector:

Exp Date:

Instructions:

Date: 07/04/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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